

Date: Wednesday, 11/21/2007 10:13:45 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SEAL
 Job Number : 35924
 Estimate Number : 13074
 P.O. Number :
 This Issue : 11/21/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11/21/2007 Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-11-19 DD verified by: EC

Part Number : D36507
 Drawing Number : D3650 UNDER REVIEW REV B U/R
 Project Number : N/A
 Drawing Revision : ~~U/R~~ Rev B U/R
 Material :
 Due Date : 11/28/2007 Qty: 2 Um: Each

Mo 8/01/21

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Cut 8168-1 seal 8.19" long as per dwg D3650

MF 07-11-21

2.0 81681 SEAL



Comment: Qty.: 0.7350 f(s)/Unit Total: 1.4700 f(s)

SEAL

batch: m/06 312

MF 07-11-21

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 8/07/02 (x2)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 115

SS 8/07/11 (x2)

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

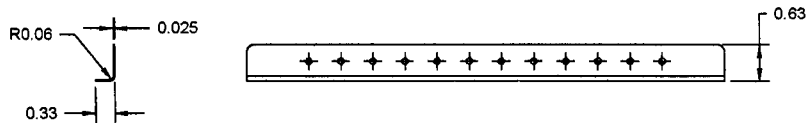


POSITIVE RECALL

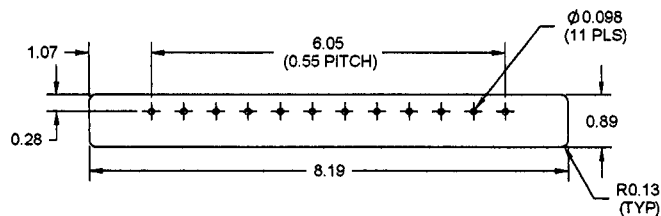
EFFECTIVE 07/11/21 AUTH 11

RELEASED 08/07/21 DATE 11

11 08.02.24



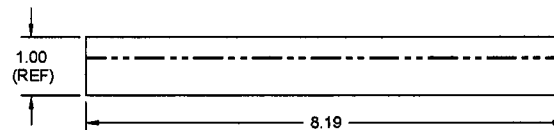
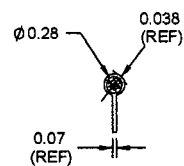
D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)
(SCALE 1:2)



D3650-9F FLAT PATTERN
(SCALE 1:2)

D3650-9 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.025 THICK (24 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S24GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3650-9 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs

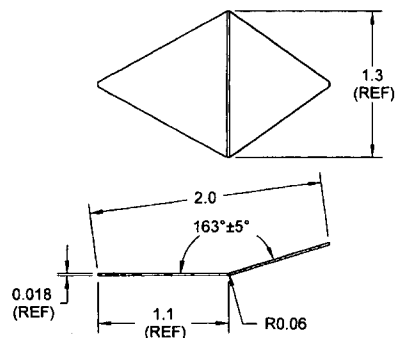


D3650-7 SEAL
(SCALE 1:2)

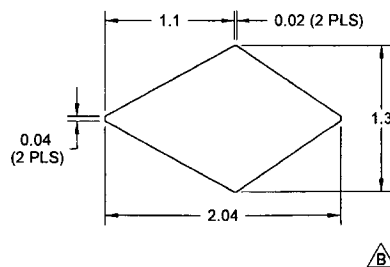
D3650-7 NOTES:

- 1) MATERIAL: P/N 41521X120HK-FT TADPOLE SEAL (REF. BELL P/N 120-104-1) POSSIBLE SUPPLIER: KIRKILL-TA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3650-7 USING FINE POINT PERMANENT INK MARKER

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3650	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:8
DATE	07.11.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



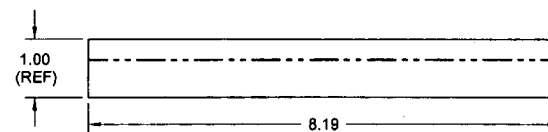
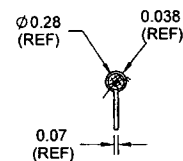
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



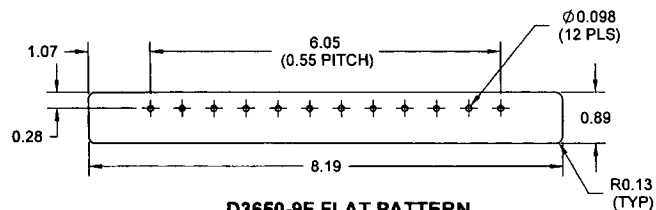
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

W/O 35924

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3650	SHEET 9 OF 9
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	TOP PANEL ASSEMBLY	1:2
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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